

WHAT IS CLAIMED IS:

- Sub R1/
1. A cutting tool for cutting a workpiece comprising:  
a tool body having an outer surface  
5 thereon and a central axis therein and including at least a first and second spiraling flute in the outer surface, each flute including a plurality of inserts secured therein to define an axial rake angle, wherein the axial rake angle of the inserts varies between  
10 flutes and within each flute.
  2. The cutting tool of claim 1 wherein all of the inserts on the entire tool body are identical.
  3. The cutting tool of claim 1 wherein the tool body includes three spiraling flutes, wherein each  
15 spiraling flute has a first, second and third axial rake angle.
  4. The cutting tool of claim 3 wherein all of the inserts on the entire tool body are identical.
  5. The cutting tool of claim 4 wherein each  
20 insert has an actual length longer than the cutting edge, and the actual lengths of adjacent inserts in any flute do not circumferentially overlap.
  6. The cutting tool of claim 1 wherein the inserts each have a cutting edge and the cutting edges  
25 on adjacent inserts in any flute do not circumferentially overlap such that cutting using the cutting tool having at least two flutes with differing axial rake angles results in an all effective cut.
  7. The cutting tool of claim 1 wherein the  
30 inserts each have a cutting edge and the cutting edges on inserts with differing axial rake angles have differing cutting edge lengths.

8. A cutting tool comprising:

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13. The cutting tool of claim 12 wherein each insert has an actual length longer than the cutting edge, and the actual lengths of adjacent inserts in any flute do not circumferentially overlap.

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1. The first part of the document is a list of references. The references are listed in two columns. The first column contains references to books and articles, and the second column contains references to books and articles. The references are listed in alphabetical order.